

# Work Order ID 50101 - 2

July 13, 2009 3:46:55 PM



Page 1

Item ID: D3295-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Window

Start Date: 7/10/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3295

Rev D

16

Photo →

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3295 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Remove plastic and wrap in saran wrap. ☐ 2-Debur if necessary

RB 9-7-31

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB 9-7-31

16

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ 8 09107131

4/4

89

12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Sm Fals NCR: Yes No DQA: LA Date: 09-08-18  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 09-06-20

NCR: 50101-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/31	#2 100	two windows were found with the .0156" holes too large .0170" R.4 Jet offset was not	RB 09/07/21	Scrap and Destroy Qty 12 No replace etxns were made	RB 9/7/31	S 09/07/31	RB 09/07/21	S 09/07/31
	water jet	<del>water jet</del> adjusted correctly,						

NOTE: Date & initial all entries

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Item ID: D3295-041

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Setup Start



Revision ID: D

Stop



Item Name: Floor Window

Start Date: 7/10/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3295. <input type="checkbox"/> Put window in plastic wrap.								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Identify as per dwg & Stock Location: <u>2/2</u>								
Packaging	Memo	0.00							
Packaging									

9/5/09/08/05 (14)

2) 80968605

(+14) 6

9/5/11 (44) 84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



**Work Order ID 50101**

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Item ID: D3295-041 Accept  Setup Start   
Revision ID: D Stop   
Item Name: Floor Window  
Start Date: 7/10/09 Start Qty: 10.00  Cust Item ID:  
Required Date: 7/31/09 Req'd Qty: 10.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC21 - Final Inspection - Work Order Release  Memo	0.00  0.00							 09/08/17  MF 09-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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July 30, 2009 11:18:48 AM

Work Order ID: 50101



Parent Item: D3295-041RevD



Parent Item Name: Floor Window

Start Date: 7/10/09

Required Date: 7/31/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-9034-01		Purchased	No				sf	148.0000	12.4000			



1/8" 9034 Lexan Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	148	
106173	96	
106403	52	

106173 1B 9-7-30

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50101-2
<b>Description:</b> Window		<b>Part Number:</b> D3295
<b>Inspection Dwg:</b> D3295	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.158	*			
17.13	+/-0.030	17.13	*			
10.43	+/-0.030	10.43	*			
14.35	+/-0.030	14.35	*			
8.98	+/-0.030	8.98	*			
0.625	+/-0.010	.624	*			
7.109	+/-0.010	7.110	*			
15.845	+/-0.010	15.845	*			
2.308	+/-0.010	2.310	*			
5.420	+/-0.010	5.424	*			
9.402	+/-0.010	9.410	*			
1.312	+/-0.010	1.311	*			
6.260	+/-0.010	6.260	*			
12.520	+/-0.010	12.520	*			
0.313	+/-0.010	.311	*			
3.750	+/-0.010	3.750	*			
8.150	+/-0.010	8.152	*			
9.006	+/-0.010	9.008	*			
0.125	+/-0.010	.118	*			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-7-31	<b>Date:</b> 09/07/31	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	



